

Date: Thursday, 8/30/2007 3:50:27 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT
Job Number	: 34355		
Estimate Number	: 10532		
P.O. Number	: NA	Part Number	: K10003
This Issue	: 8/30/2007 S.O. No. : N/A	Drawing Number	: IIN D205-634 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NA Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 33461	Material	: N/A
Written By	:	Due Date	: 9/30/2007 Qty: 6 Um: Each
Checked & Approved By	: <u>JA 07.08.31</u>		
Comment	Est: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est: J 06-07-25 As per DSI 9344 JLM Est: K 06.11.17 Per K10003 Rev C KJ Est Rev: L 07.01.12 Document Record for copying bluefile rmv KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003 CHG 005

07.10.04 KJ

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2570	Bushing
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	B33468 (78A) - B33559 (66X)

4.0	D2571	Saddle, Fwd, Out
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	B31806

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34355

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	B31648 (4) - B31714 (4) -

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	B31721 -

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	B32168 (4) - 2x 34370

8.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	B32511 -

9.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	B33082 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SADDLE KIT

Job Number: 34355

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	B33470

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	B31227 (12) - 329789 (11) -

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	B32104

13.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	B33287

14.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Set Screw

Batch: B28093

15.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty

Part Number

Description

Batch

16

AN4-6A

Bolt

M105057-

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN4-46A

Bolt

M104975-

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN4-51A

Bolt

M103684 (44+) M105281 (44+)

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN6-12A

Bolt

M105558-

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 192.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

32

AN960JD416

Washer

M104746-

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

8

AN960JD616

Washer

M104745-

Ep 507/10/01 (6)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 07/10/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 34355

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer

HIT



JS



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

1

AN970-4

Washer

M104865-

22.0

MS21042L4

Nut

HIT



JS



Comment: Qty.: 29.0000 Each(s)/Unit Total : 174.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

29

MS21042L4

Nut (or MS21042-4)

M104683-

JS 7/12/01 (6)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



JS



Comment: INSPECT KITS 100% FOR COMPLETENESS

JS 7/12/04 (6)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

H

JS 7/12/07

(6)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

JS 7/12/05

Job Completion



U 7-10-05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## 5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D2968-041	TOW RING
41	1	1				AN970-4	WASHER
43	1	1				MS21042L4	NUT (OR MS21042-4)
50					1	D2736-1	GHW LUG
51					1	D2736-3	GHW LUG
52					4	AN4-46A	BOLT
53					8	D2570	BUSHING
54					4	MS21042L4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Date: 07.04.10

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